

Date: Friday, 19/12/2008 10:42:36 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LONG PIN BRACKET
Job Number :	44203		
Estimate Number :	11204		
P.O. Number :		Part Number :	D333011
This Issue :	19/12/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3330 REV D
First Issue :	1/1	Project Number :	N/A
Previous Run :	39321	Drawing Revision :	D
	Type :	Material :	
	MACHINED PARTS	Due Date :	28/12/2008
Written By :		Qty:	8
Checked & Approved By :	<u>JW 08.12.09</u>	Um:	Each
Comment :	Est. A05.01.13 New issue KJ/JLM est b 07.05.14 rev c dwg ec est C 07.12.12 rev D dwg EC verified by:DD		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M1010B2500X01000

1010-1025 Steel Bar 2.50 x 1.00



Comment: Qty.: 0.2734 f(s)/Unit Total: 2.1874 f(s)

1010-1025 Steel Bar

Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel(

M1010-B2.500x01.000)

Identify for D3330-11

Batch: M106317

MR 09/01/09

5

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks: 2.500" x 1.000" x 5.00" long (+/-0.030)

MR 09/01/09

5

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA479 and Dwg D3330

Identify as D3330-11

Debur

J.F. 09/01/10

5

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/01/10

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 19/12/2008 10:42:36 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG PIN BRACKET

Job Number: 44203

Part Number: D333011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 09/01/11

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: carl

9/1/12

5x

sp

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/14 JF

Job Completion



MF 09-0112

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44203
Description: Long Pin Bracket		Part Number: D3330-11
Inspection Dwg: D3330	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

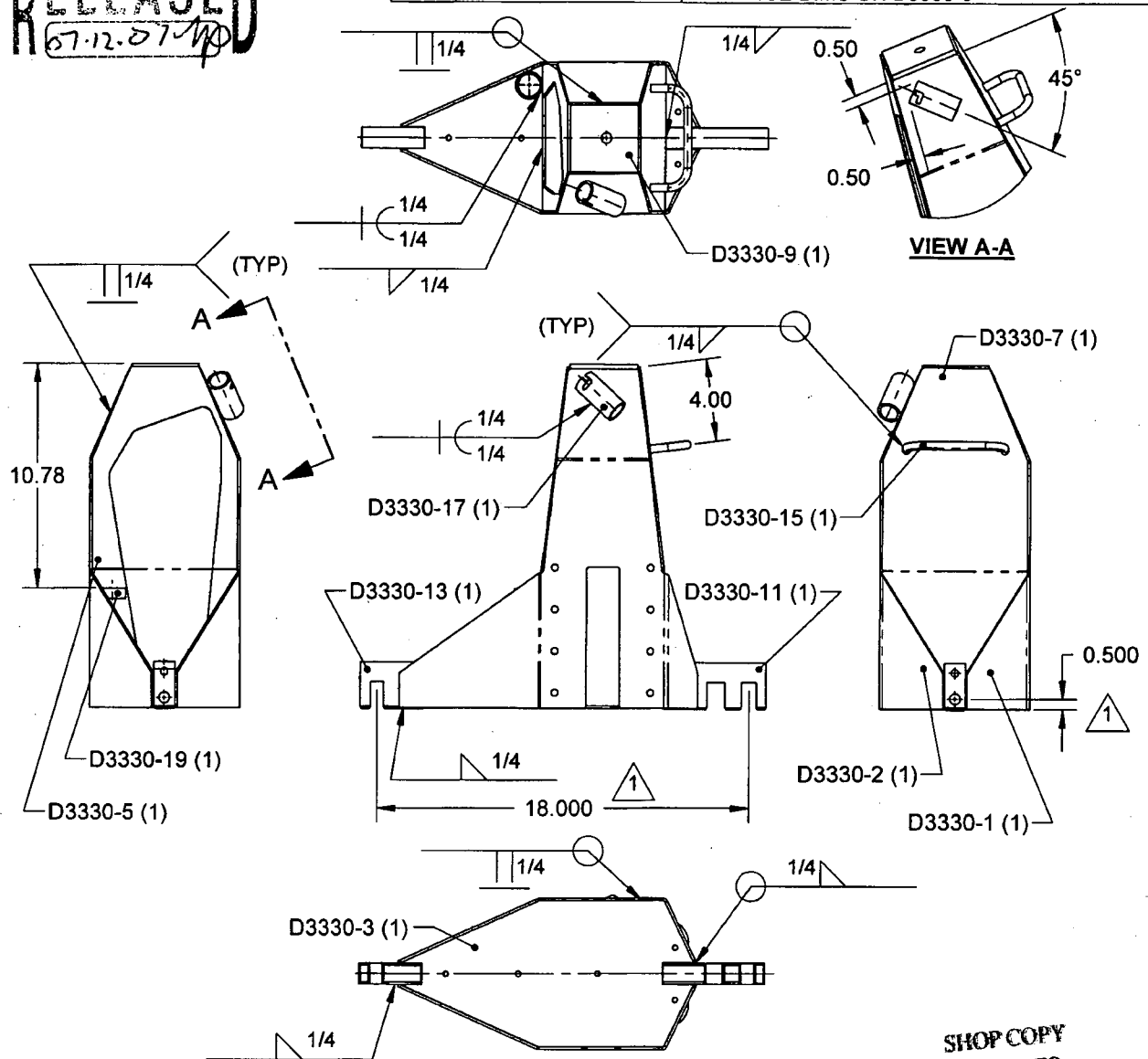
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.00	+/-0.030	5.028"	✓			
4.625	+/-0.010	4.630"	✓			
0.260	+/-0.010	.260"	✓			
Ø0.594	+0.005/-0.000	.595"	✓			
0.875	+/-0.010	.877"	✓			
0.838	+/-0.010	.837"	✓			
0.700	+/-0.010	.701"	✓			
0.500	+/-0.010	.510"	✓			
2.25	+/-0.030	2.251"	✓			
0.950	+/-0.010	.951"	✓			
* Ø0.531	+0.005/-0.000	Ø.536"	✓			
Ø0.348	+0.005/-0.000	Ø.349"	✓			
Ø0.516	+0.005/-0.000	Ø.517"	✓			
0.467	+/-0.010	.463"	✓			
* 1.250	+/-0.010	1.251"	✓			
1.00	+/-0.030	.996"	✓			
0.10 x 45°	+/-0.5°	.110"	✓			

Measured by: J.F.	Audited by: J.L.	Prototype Approval: N/A
Date: 09/01/10	Date: 09/01/11	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.05.10	New Issue	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.05.16	Dwg Rev updated	KJ/EC	
D	07.11.23	0.838 was 0.837	KJ/EC/DD	

DART**RELEASED**
07-12-07

DESIGN 13	DRAWN BY DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED [Signature]	DRAWING NO. D3330	REV. D SHEET 1 OF 9
DATE 07.12.06	TITLE FRAME WELDMENT		SCALE 1:8
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/2 BY 0.125	
D	07.12.06	CHANGE DIMS ON D3330-9	

**D3330-041 FRAME WELDMENT****NOTES:**

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

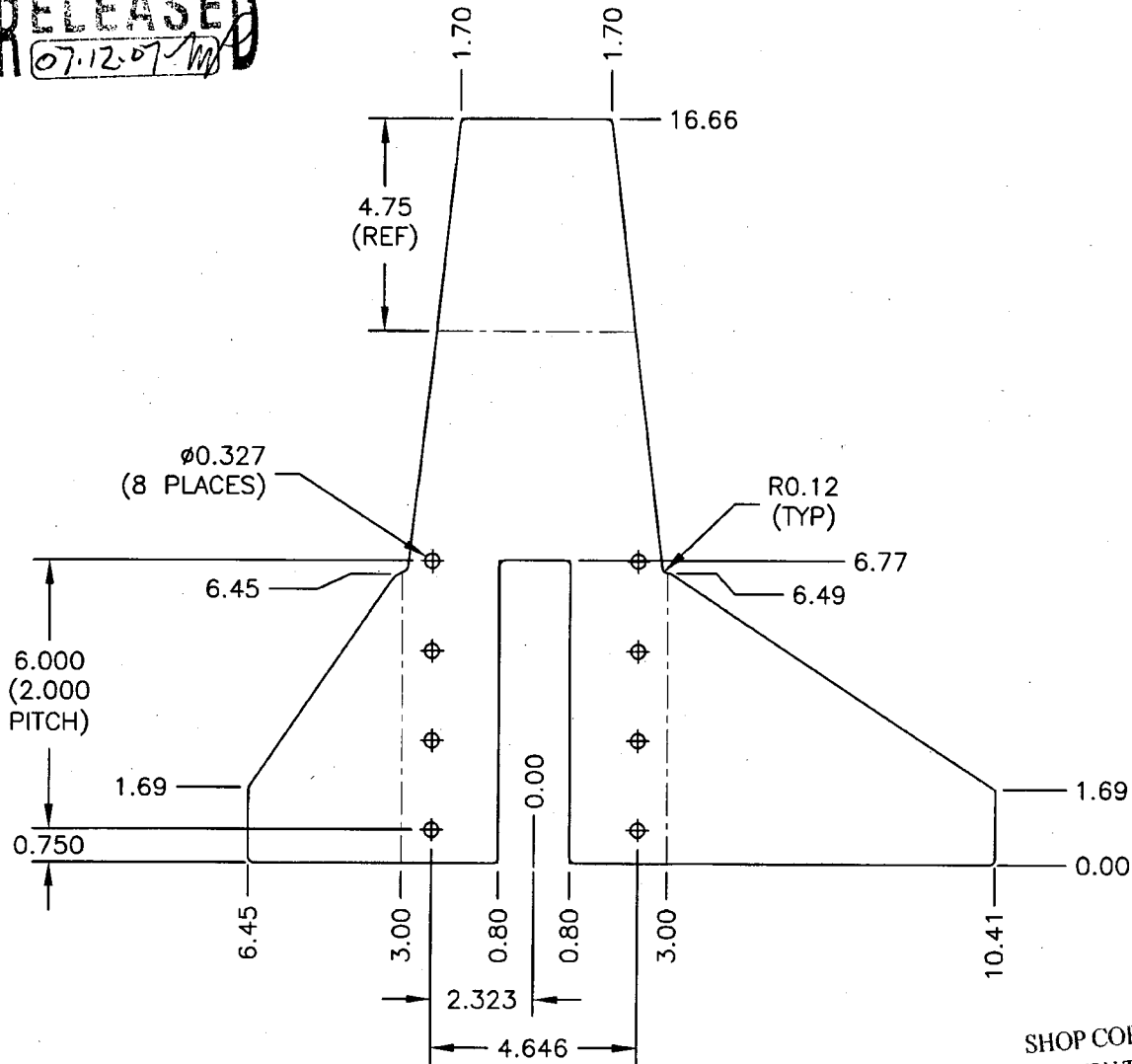
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

RELEASED
07.12.07 *[Signature]***D3330-1 PANEL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, NO. 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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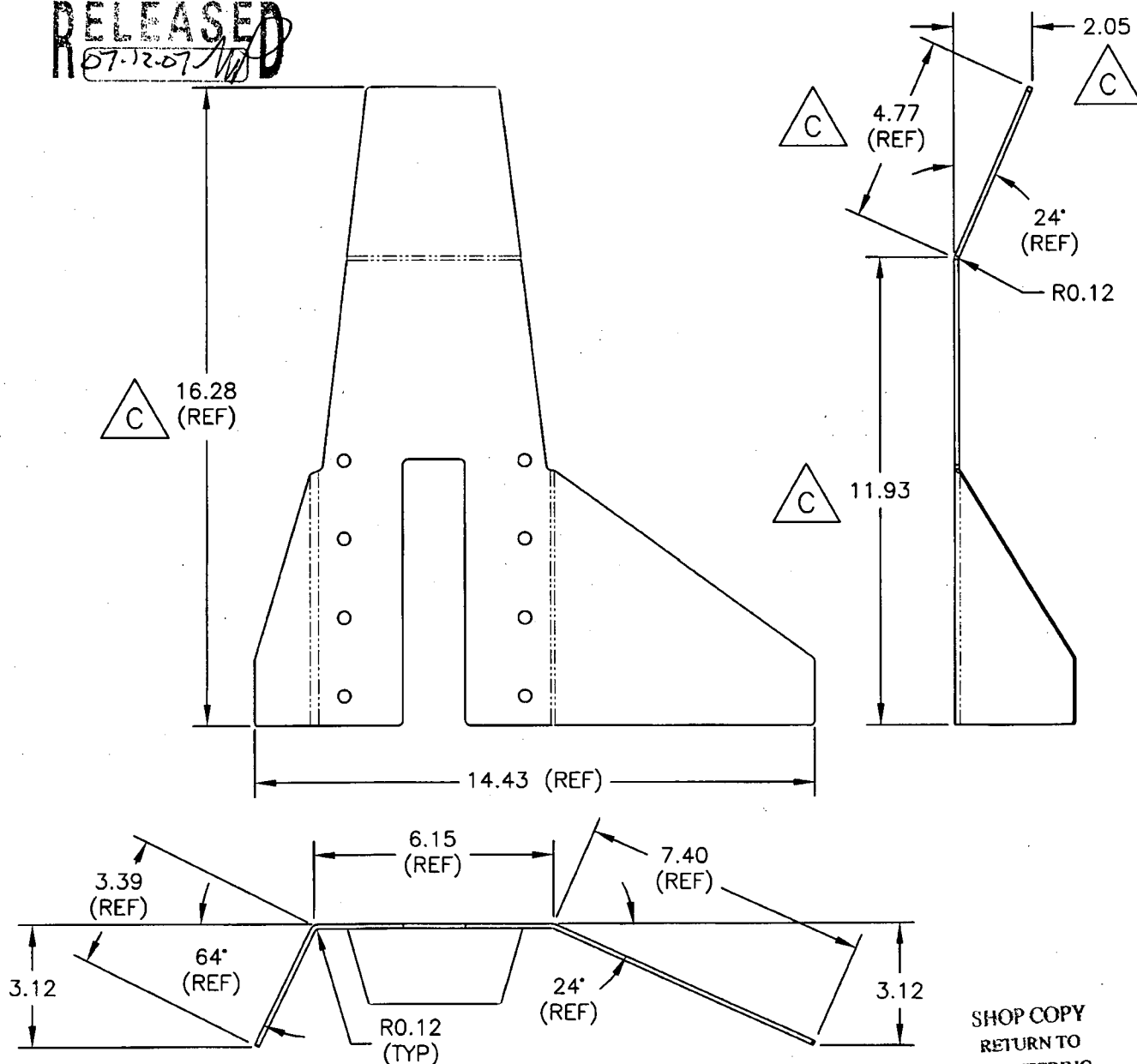
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

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D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

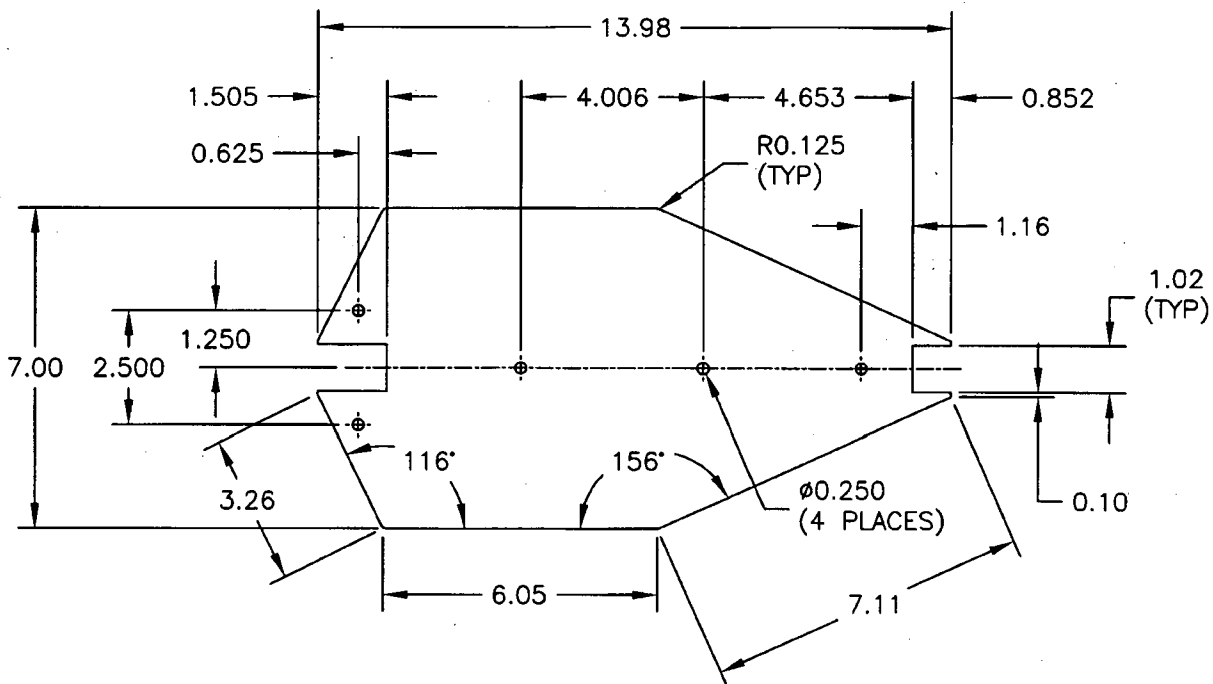
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

RELEASED
07.12.07 *MP***D3330-3 PLATE**

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NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

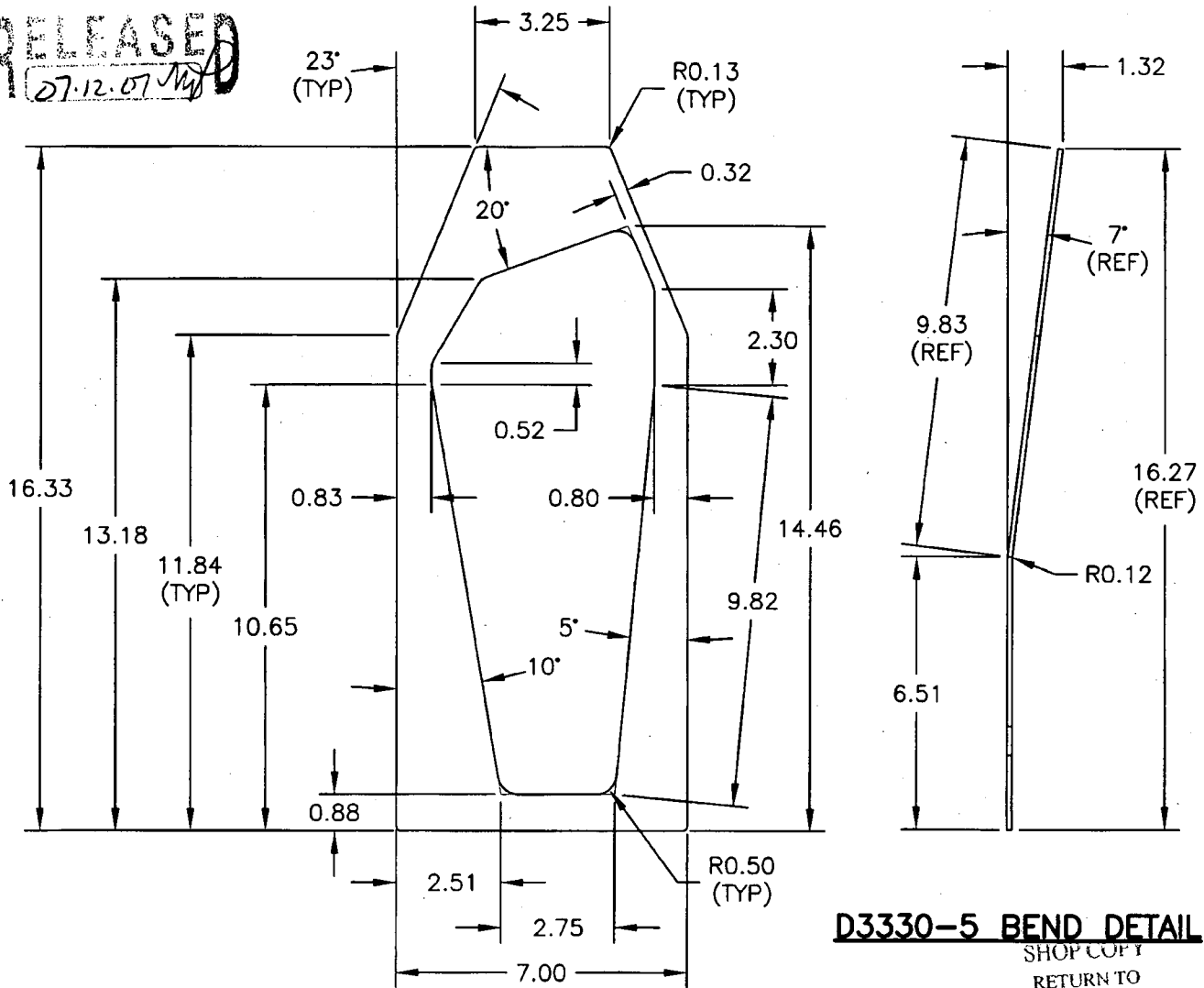
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**FLAT PATTERN****D3330-5 BEND DETAIL**

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NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

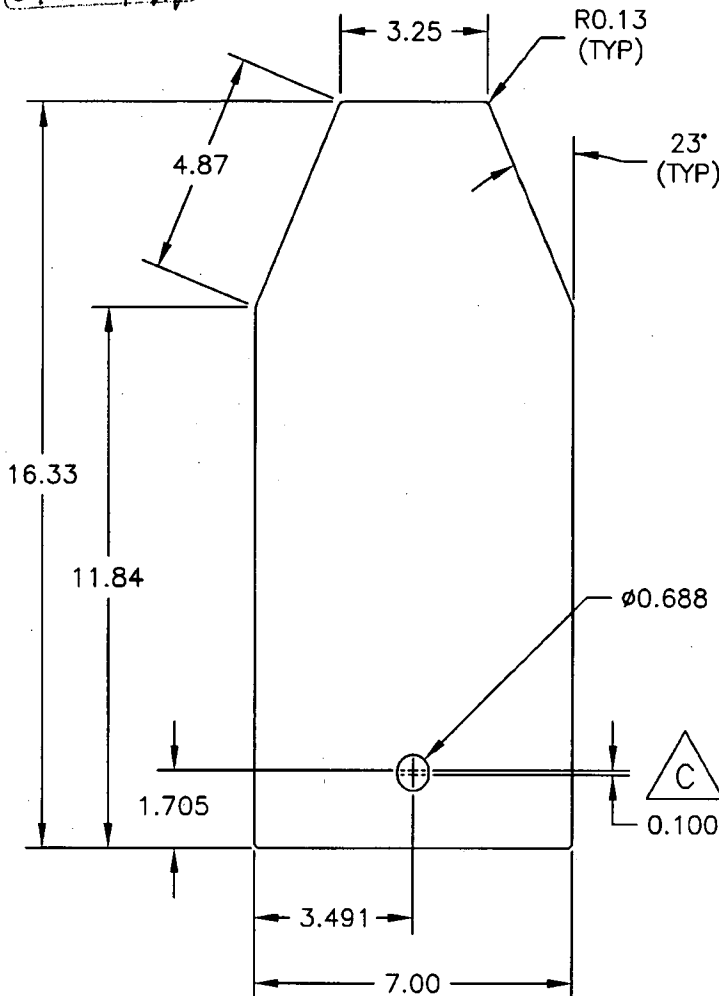
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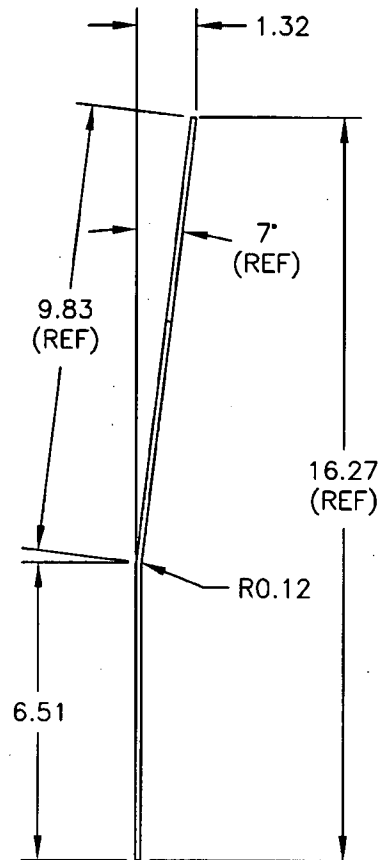


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DATE 07.12.06		TITLE FRAME ASSEMBLY	SCALE 1:4

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FLAT PATTERN



D3330-7 BEND DETAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125" THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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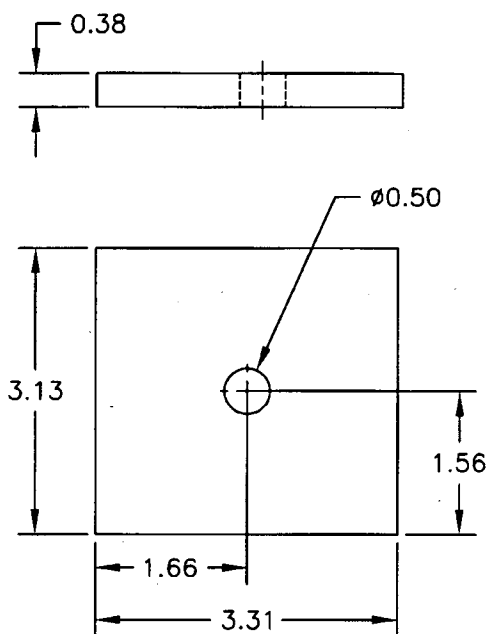
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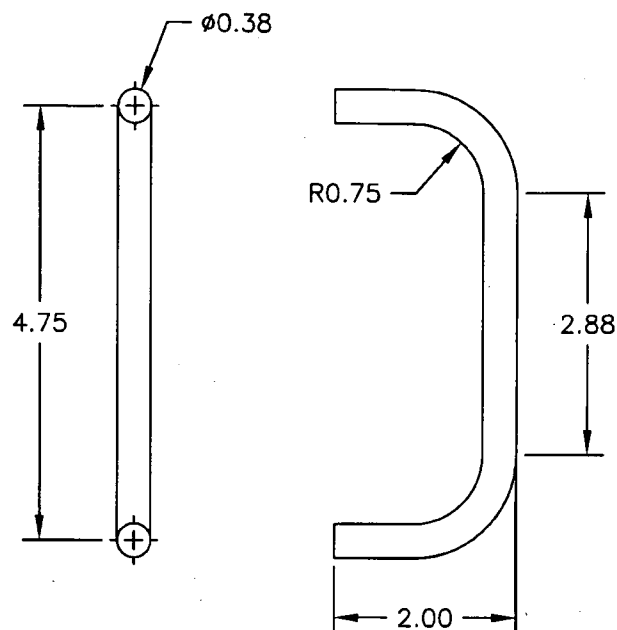


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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:2

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07.12.07



1 D3330-9 TOP PLATE



2 D3330-15 HANDLE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL (REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097 (REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

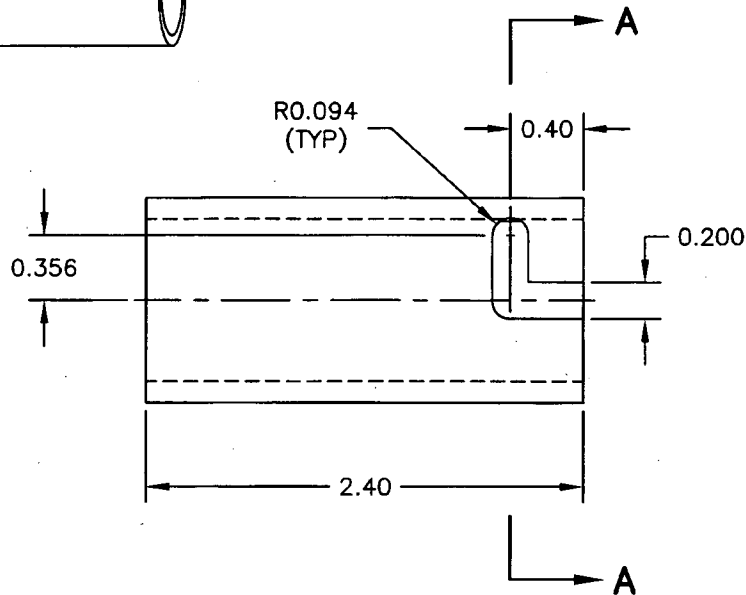
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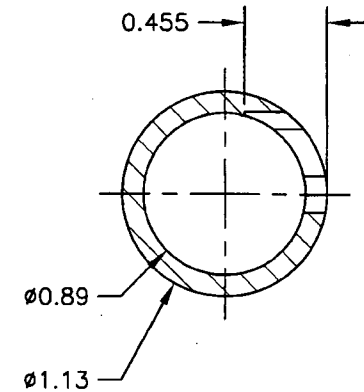
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DATE 07.12.06	TITLE FRAME WELDMENT		SCALE 1:1

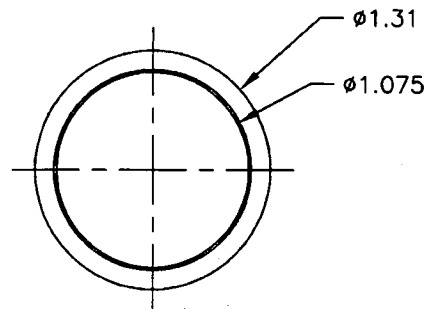
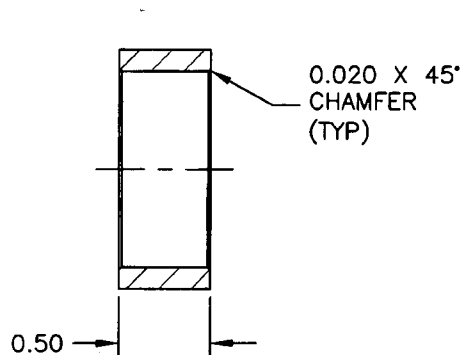


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07.12.07



SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

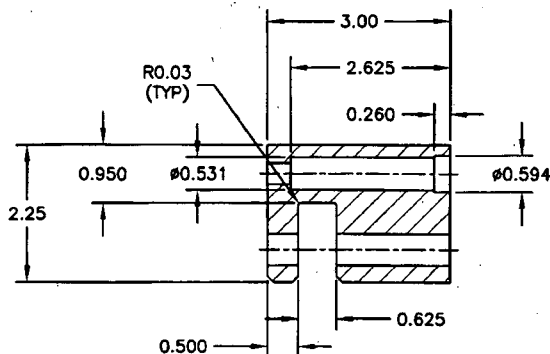
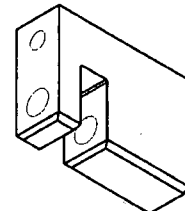
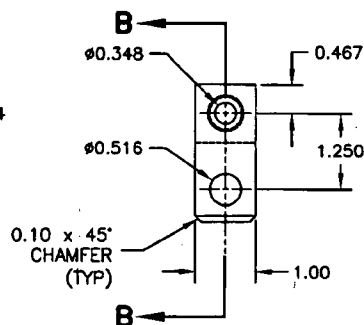
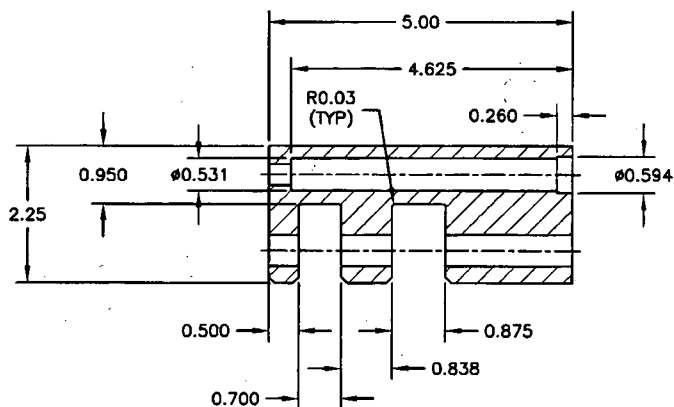
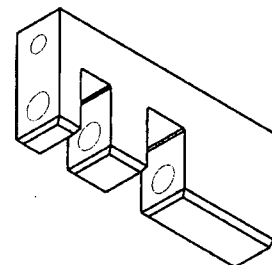
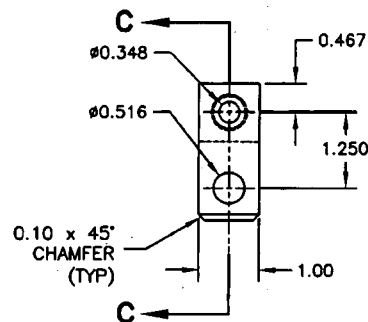
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:3

RELEASED
07.12.07**SECTION B-B****D3330-13 SHORT PIN BRACKET****SECTION C-C****D3330-11 LONG PIN BRACKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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